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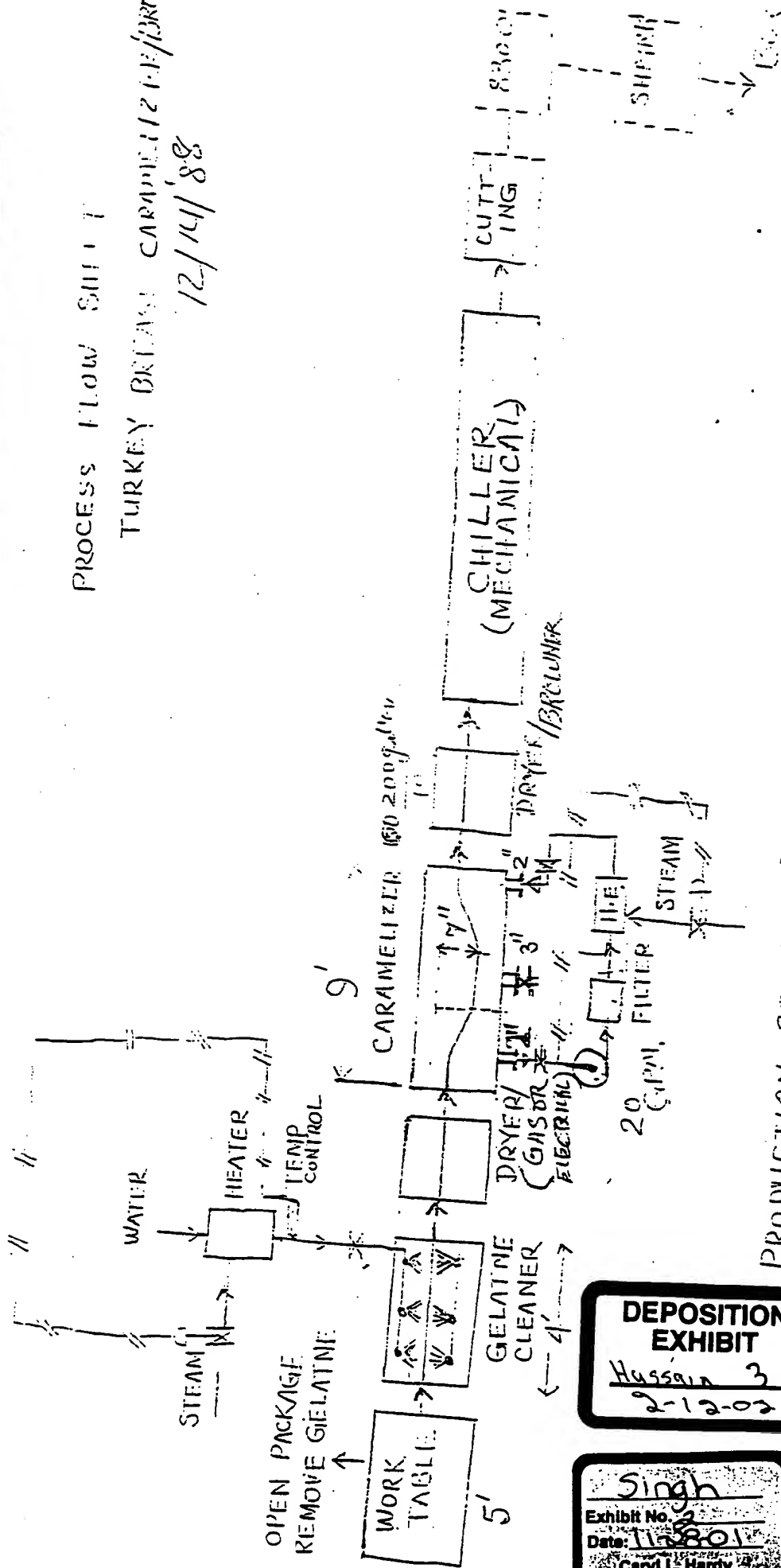
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PROCESS FLOW SHEET

TURKEY BREAST CARAMEL 12/13/88

12/14/88



PRODUCTION SPEED - 20 PIECES/MINUTE/UNCUT
 CARAMEL TIME - 20-25 SECONDS (BROWNING TIME DETAIL NOTE)
 PRODUCT TEMP - 40°F (AT THE WORK TABLE)
 PRODUCT FROM CHILLER MUST BE AT 40° OR LOWER
 PRODUCT FROM BOTH DRYERS MUST BE DRY TO THE TOUCH
 PROCESS PIPING AND CONTROL SUPPLIED BY ELECTRIC/PLUMBING

DEPOSITION
EXHIBIT

Hussain 3
2-12-02

DEPOSITION
EXHIBIT

Sch 3
2-13-02

Singh
Exhibit No. 3
Date: 11-28-01
Caryl L. Hardy

CONFIDENTIAL -
Restricted Access

PTO-002363

CRPF04014

I. ITEM:

OVEN PREPARED TURKEY BREAST BROWNED WITH CARAMEL COLOR
 BUTTERBALL UPC: 29048, 29041
 GOLDCREST UPC: 29051, 29591
 PLANT: WELLS, MN

PAGES: 13

PREPARED BY: CB

ISSUE NO: 16

REPLACES ISSUE: 15

EFFECTIVE DATE: 01/29/91

DATED: 04/01/89

APPROVALS:

PLANT MANAGER:

OPERATIONS:

R&D: CB

II. COMPOSITION:

A. SPEC
CODE

COMPOSITION

LBS./100
LBS. MEAT

%

SM-936	Turkey Breast	1000.000	78.125
SI-900	Water	193.200	15.093
L-963	Sodium Lactate	42.200	3.297
1-984	Modified Food Starch	16.600	1.297
SI-550	Salt	12.800	1.000
SI-406	Dextrose	9.500	.742
SI-408	Sodium Phosphates	5.000	.391
SI-002	Onion/Celery Juice	.600	.047
L439	Authentic Soluble Black Pepper	.100	.008

Totals----- 1280.000 100.0000

B. Finished Product Ingredient Statement: Turkey Breast,
 Water, Sodium Lactate, Modified food Starch, Salt,
 Sodium Phosphates, Flavorings.

C. Qualifying Statement: Browned With Caramel Color

REFERENCES:

- A. Product Formula: BB29048
 B. Product Standards: BB-29048-PD, MP-29051-PD
 C. Cleaning Procedures: CP002 (General), CP009
 D. Equipment Procedures:

IV. EQUIPMENT LIST:

- A. Pickle Tank
 B. Recirculation Pump
 C. Injector
 D. Massager
 E. Curwood Packaging Machine
 F. Cooking Racks
 G. Hot Oil Dip

- H. Knife
 I. 8300 Machine
 J. Shrink Tunnel
 K. Stainless Tables
 L. Scales
 M. Conveyors

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CRPF04243

DEPOSITION
 EXHIBIT

Hussain 4

2-12-03

Singh

Exhibit No. 3

Date: 11-28-01

Caryl L. Hardy

PRODUCT: OP TURKEY BREAST BROWNED WITH CARAMEL COLOR
UPC: 29048, 29041, 29051, 29591

VI. MANUFACTURING PROCEDURES:

A. PROCESSING

1. Receiving:

- a. Q.A. will check each incoming load of fresh turkey breast halves with skin.
(Q.A. 1213)

i. MAXIMUM TEMPERATURE: 40 DEG. F (per Q.A. 1226)

ii. MAXIMUM AGE: 96 HOURS FROM BONING
(per Q.A. 1226).

- b. Check for defects per Q.A. Procedure 1216 as well as for foreign material, off color, and off odor.

- c. Product will be held in 28 deg. F cooler until ready for use.

- d. When needed, transfer turkey breast directly to the injection area in processing room.

NOTE: Processing room should be refrigerated to a maximum of 50 deg. F.

2. Injection Solution Preparation:

- a. ALL INJECTION EQUIPMENT MUST BE SANITIZED WITH 200 PPM CHLORINE PRIOR TO USE.

NOTE: This includes kettles, pumps, piping, injector reservoir and hoses. 1000 LBS.

b. Formula:

<u>Ingredient</u>	<u>%</u>	<u>lbs</u>
Water (SI-900)	68.979	689.79
Sodium Lactate (L-963)	15.071	150.71
Modified Food Starch (SI-984)	5.943	59.43
Salt (SI-550)	4.571	45.71
Dextrose (SI-406)	3.400	34.00
Sodium Phosphates (SI-408)	1.786	17.46
Onion/Celery Juice (SI-002)	.214	2.14
Authentic Soluble Pepper	.036	.36
Totals-----	100.000	1000.00

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CRPF04244

- c. Only enough solution for one day's production should be made, as it must not be held overnight.
- i. PROCESS CONTROL CHECKLIST FOR MIXING MUST BE MAINTAINED WHILE MIXING BY OPERATOR.
- ii. Check weights and appearance of ingredients as added.
- d. Water is added through a water meter to a marked kettle and recirculating pump and Lightning Mixer started. (All water used in injection solutions must be filtered 5 micron or less.
- e. Sodium phosphate is slowly added to water. PHOSPHATE MUST BE IN SOLUTION. Minimum mix time:
- f. Salt is slowly added to water. SALT MUST BE IN SOLUTION.
- g. Modified Food Starch is slowly added to water.
- h. Add Sodium Lactate through automatic metering dispenser.
- i. Add onion/celery juice and Authentic soluble pepper. Ingredients in solution must be totally dissolved before use.
- j. Salometer reading should be from 50-56%.
- NOTE: If salometer reading falls outside this range, the pickle must be dumped and a fresh batch made.
- k. Finished solution must be mixing and recirculating to stay in suspension.
3. Injection:
- a. Operator will weigh breasts before injection to calculate weight gain. Check at start of production and each period.
- b. Adjust belt speed to injected, pickle pressure, and hold down pressure to achieve proper weight gain.
- NOTE: TARGET FOR 28% INJECTION.
- c. Keep reservoir recirculating pump running continuously. Bleed air from injector head continuously via modified bleed system.
- d. Place meat on the inspection table, skin side up, and pass through injector and tenderizer head and into stainless holding tank on a scale.

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- e. Record the weight of the injected breasts and calculate pump gain. Add pickle solution to reach desired weight.
 - i. MAXIMUM ADD BACK: 20# PER 1000# OF MEAT.
 - ii. If more than 20# is needed, injector should be checked for mechanical problem.
 - f. OPERATOR WILL MAINTAIN PROCESS CONTROL RECORDS FOR INJECTION.
 - g. Transfer pumped breasts to massaging.
4. Massaging/Tumbling:
- a. Injected meat weight is scaled when it is in the holding tank.
 - i. Maximum weight in the tumbler is 8000 lbs.
 - ii. Vacuum load the injected breast into the tumbler.
 - b. Do not overload tumbler above recommended weights as product will not massage properly.
 - c. Close lid and pull vacuum to 24" and tumble.
 - i. Tumble time: 2 1/2 hours at 3 1/2 rpm.
 - ii. Properly tumbled product will be dry, pliable, and very tacky.
 - d. OPERATOR WILL MAINTAIN PROCESS CONTROL RECORDS FOR TUMBLING.
 - e. Transfer injected and tumbled breasts to Curwood/Pioneer machine.
 - i. Injected and tumbled meat may be held in 28 deg. F cooler overnight.
 - ii. Injected, tumbled, and packaged meat must be held in a 28 deg. F cooler if not used within 1 hour of processing.

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5. Curwood Packaging:

- a. After tumbling, skin will be inspected for presence of holes, pin feathers or bruises.
- b. Place inspected breast in Curwood film cook-in-bag mold.
 - i. Place one skin-on half breast, with tenderloin (maximum 1 tenderloin per package), in the cavity of the four across Curwood machine.
 - ii. Load with skin-on side down.
 - iii. Smooth skin over breast meat.
- c. Wipe film dry in seal area and advance breasts through Posi-seal and cut.
- d. Inspect finished packages for leakers, assembly and forming.

6. Racking:

- a. Acceptable product is placed on oven racks.

4 x 9 pattern
396 pieces/rack
- b. Breasts may touch each other but should not be crowded.
- c. Position uniformly to prevent dents.
- d. Transfer racked product to ovens for heat processing if ovens are to be started in one hour.
 - i. If ovens are not started in one hour, transfer racked product to cooler.
 - ii. Packaged raw product shall not be aged longer than 24 hours.

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PRODUCT: OP TURKEY BREAST BROWNED WITH CARAMEL COLOR
UPC: 29048, 29041, 29051, 29591

B. COOKING

1. Position racks in ovens in 2 rows along centerline of oven. Do not position racks along edge under smoke tubes.
2. Check wet bulb reservoir for water.
3. Insert calibrated thermometer in large breast to monitor core temperature. Position next to window in oven door.
4. Seal oven doors and cook using wet bulb only according to the following schedule.

<u>Time</u>	<u>Wet Bulb Temperature</u>
45 min.	140 deg. F
45 min.	160 deg. F
60 min.	180 deg. F
Remainder (60 min.)	170 deg. F

NOTE: If not to temperature, finish at 170 deg. F

5. COOK TO AN INTERNAL TEMPERATURE OF 162 DEG. F.

- a. Cook operator will check temperature of thermometer in breast near oven window and double check with a second breast.
 - i. Select a breast on the 5th or 6th layer from the top of a cook rack.
 - ii. Insert calibrated thermometer in a large breast near inside of racks to verify 162 deg. F internal temperature.
 - iii. If 162 deg. F internal temperature is not reached, extend last cycle and check every 10 minutes until desired temperature is met.
 - iv. Record temperature on house chart and initial. Supervisor will verify temperature of pulled product, enter it on house chart and initial.
- b. The cook cycle that the chart indicates will be examined for accuracy and verify product has gone through proper cycles.
- c. PROCESS CONTROL/O.A. AND SUPERVISOR WILL VERIFY THIS INFORMATION AT THE END OF EACH SHIFT.

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- d. If the product has reached internal temperature of 162 deg. F, turn off ovens and open dampers to allow hot air to escape.
6. Showering:
 - a. After internal temperature of 162 deg. F is reached, shower with tap water for 1 hours.
 - b. Reduce temperature to approximately 125 deg. F.
7. Cooling:
 - a. After showering, transfer product to 26-28 deg. F blast cooler.
 - b. PRODUCT MUST BE 40 DEG. F OR LESS BEFORE TRANSFER TO BLAST CHILL ROOM.
If internal is above 40 deg. F, a longer period of time will be required to reduce the internal temperature.
 - c. Transfer to blast chill room.
8. Blast Chill Room: (0 deg.F)
 - a. Hold in blast chill room only long enough to achieve an internal temperature of 29 deg. F +/- 2 deg. F. Product above 31 deg. F will not be below 40 deg. F when exiting from freezer unit.
 - b. Crust freezing will occur, but will not be detrimental to the product.
 - c. When internal temperature reaches 30 deg. F, transfer to strip and staging room.
 - d. If product internal drops below 28 deg. F, transfer product to blast cooler. Approximately 10 mins. Before rack goes to stripping, return to blast chiller for external chilling.

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9. Stripping and Staging Room:

- a. Prior to stripping, sanitize Strip and Staging Room as follows:
(Strip and Staging Room is refrigerated at 40 deg. F.)
 - i. Unwrap table and floor with 200 ppm chlorine solution.
11. Equipment and floors will be kept clean and as dry as possible.
- iii. Gloves and aprons, worn by all production personnel, will be sanitized and changed each break.
- iv. Sanitize bag, and knife to slit bag, with 200 ppm chlorine.
- b. Transfer only one rack at a time to the stripping and staging room.
- c. Temperature of product needs to be as cold as possible and should not remain in stripping room over 20 minutes.
- d. If breakdown or stoppage occurs, return unstripped product to 26 - 28 deg. F blast cooler.
- e. If internal temperature surpasses 30 deg. F in blast cooler, product must be returned to blast chill and reduced to the 30 deg. F temperature before returning to stripping room.
- f. Strip bag from product.

10. Caramelizing Room (not refrigerated):

a. Caramel Color Make-up:

- i. Prior to start of days production, 100 gallon 1.6% +/- 0.5% caramel solution should be made.
 1. Add normal tap water to the mixing kettle with a lightning mixer attached. Add only enough for one (1) days production.
 2. Add powdered caramel (1) Williamson 622 or (2) Sethness RT 127 to make a 1.6% solution. Make only enough for one (1) days production. $100 \times 8.3 = 830$ lbs. water.
 $830 \times 0.015 = 12.45$ lbs. caramel
Turn on cold water. Place caramel in Hopper of Eductor and allow all caramel to go into solution. Continue filling tank to 20.5 in. Measure from the middle along side the propeller.

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3. Check % in Spectrophotometer.
4. If not at the 1.6%, add 0.5 in. at a time until at 1.6%.
- b. Start of Caramelizer:
 1. Fill caramel reservoir (empty of product) to 7 1/2 on sight glass.
 2. Turn on heat exchanger set for 170 deg. F and start recirculating pump.
- c. Place stripped breasts on conveyor of degelatinizer. Breasts should be palced four (4) across with one (1) rod, approximately 1 in. between rows.
 - i. Conveyor will advance breast through degelatinizer. Spray water. Temperature through spray nozzle will be 170 deg. F. Time through degelatinizer is four (4) foot per minute. Exit degelatinizer to dryer.
- d. Product will advance onto conveyor and through the first high heat, high velocity air dryer. Temperature of dryer will be 400 deg. F. Time through dryer will be four (4) foot per minute. Exit dryer onto conveyor of caramelizer.
- e. Caramel Level Control:

Valve within the line to caramelizing unit will control addition of 1.6% solution from the make-up tank. Make-up will be added when needed.
- f. Caramel Solution Control:

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 - i. Strenght of caramel solution within the caramelizing tank will be controlled by adding from the solution mixing unit to a level in sight glass, at the very top of the sight glass when the conveyor is full.
 - ii. A Coleman 35 Spectrophotometer will be used to determine solution percentage.
 - iii. Clean filter at breaks when product is not in caramel solution.
- g. Product will advance onto conveyor and through the caramelizer. The conveyor is constructed so the product will be completely submerged for a period of time in 170 deg. F -- 1.5% caramel solution. Caramelizing time travel will be four (4) foot per minute. Exit caramelizer onto conveyor of second dryer.

h. Product will advance onto conveyor and through second high heat, high velocity air dryer. Temperature of dryer will be 250 deg. F. Time through dryer will be four (4) foot per minute. Exit dryer onto conveyor into chill unit.

11. Chill Unit Room (45 deg.F.), Freezer Unit (-23 degF)

Product will advance through the Enersyst cooling system. Product will enter cooling unit at four (4) foot per minute. Internal temperature of product must be 40 deg. F or less at the end of this time. Transfer to cutting and packaging.

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PRODUCT: OP TURKEY BREAST BROWNED WITH CARAMEL COLOR
UPC: 29048, 29041, 29051, 29591

C. PACKAGING

1. Shelf life of this product will depend on control of contamination between cooking and final packaging. The following steps must be followed:
 - a. All equipment and floors must be thoroughly cleaned and sanitized prior to packaging.
 - b. Keep equipment and floors as dry as possible during operation.
 - c. Room temperature will be maintained at 40 deg. F or lower.
 - d. Personnel will wear disposable plastic aprons. The aprons will be changed at each break, gloves with each rack of new product.
 - e. Personnel will dip hands in 50 ppm chlorine solution when they have touched items other than product.
2. Rebagging:
 - a. After chilling, browned breasts are transferred to 8300 room.
 - b. All caramelled breast are placed on automatic cutter to be cut in half.
 - c. Browned, chilled breasts should weigh approximately 1/4 - 2.0 Lbs.
 - d. Browned breasts are placed on the slide and inserted into Cryovac bags, cut end first.
 - e. Bagged breasts are placed on the 8300 machine where they are vacuum sealed.
 - f. Run sealed bags through a 190 deg. +/- 5 deg. F shrink tunnel.
 - g. Inspect finished product for compliance with product standards.
 - i. Any breast not meeting Butterball quality will be labeled and packed as Gold Crest.
 - ii. Thin slices taken from the face to remove defects will be vacuum packaged, boxed, and frozen under UPC 29591.

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PTO-002374

3. Labeling:

- a. A pre-printed pressure sensitive label is placed 1/4" from the cut surface and parallel to the cut. A "skinless" pressure sensitive label is placed on the face of the product.
- b. Mark breast with code date 70 days from date of cutting and packaging.

4. Packing:

- a. Product temperature must be maintained at 40 deg. F or less for boxing.
- b. Use a face to face configuration:

2904129048

- c. Weigh and apply weight label to box along with appropriate use by code.

5. Palletizing:

- a. Pallets will be dry, clean and free of broken boards or protruding nails.

- b. Stack boxes as follows:

- i. 29041, 29051

10 boxes/layer
14 layers/pallet
140 boxes/pallet

- ii. 29048

7 boxes/layer
12 layers/pallet
84 boxes/pallet

- c. Move palletized product to cooler and hold until ready to ship.

- d. Product will be stretch wrapped prior to shipping.

6. Shipping:

- a. Trailers should be clean, dry, and free objectionable odors.
- b. Trailers shall be swept or washed before loading if necessary.
- c. Trailers should be well insulated and tightly constructed.
- d. Recommended loading and shipping temperature: 26-28 deg. F.

- e. Load and ship product.

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CRPF04254

PTO-002375

INTEROFFICE MEMORANDUM

JAN 5 1994

DATE: January 4, 1994

TO: Dave Wiggins/Frank Carroll
Bryan Zulaica
Dennis Hull/Mark Spengler
Syed Hussain/Bill Schwartz
Keith Brickey/Stan Seavey
Brian Green/Jim Karrer Wells MN
Terri Mace ST. JAMES
Dick Sarvas

FYI: Ted Berry DG
Kent Kring/Paul Reeves DG
Lee Christiansen PDL
Bruce Tomkin PDL
Kay Jakab PDL
Frank Alexander PDL
Lynne Murray PDL
Tara-Rose O'Malley PDL

SUBJECT: CHANGE REQUEST DATED 12/30/93 FOR UPC's
45300-29041, 45300-29048, 45300-29051,
45300-23274.

PRODUCT: Skinless Slice and Serve Oven Prepared
Caramel. NOT THE MESQUITE SMOKED.

PROPOSED CHANGE: Use Maillose, an aqueous solution of
caramel coloring with a low pH 2.5 - 3.5, for
surface caramel coloring of the product. The
Maillose will be in a 12% solution and heated
to 140°F.

Please review the attached documentation change form.
The documentation, including the revised formula, is
attached for the plant and purchasing only. If you
have not already signed and you approve of the proposed
change, please sign in the space provided. If you do
not approve, make that notation on the form. Return
all forms as soon as possible. These changes are in
pending until I receive notification from the plant
that these changes have taken effect.

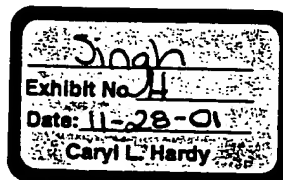
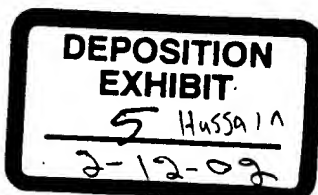
IF YOU DO NOT RESPOND WITHIN 10 DAYS OF THE DATE OF
THIS MEMO, YOUR APPROVAL WILL BE ASSUMED AND THE CHANGE
WILL BE PROCESSED AS WRITTEN!

Thank you for your cooperation.

Debbie Sommerio

DEBBIE SOMMERIO
Quality Systems
Downers Grove, IL

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CRPF02080

PTO-002376

DOCUMENTATION CHANGE FORM
REQUESTOR NAME: Syed Ajaz Hussain

DATE: 12/30/93

1. DESCRIPTION OF PROPOSED CHANGE: Use Maillose, an aqueous solution of caramel coloring with a low pH 2.5 - 3.5, for surface caramel coloring of the product. The Maillose will be in a 12% solution and heated to 140°F.

2. PRODUCTS AFFECTED BY NAME: Skinless Slice and Serve Oven Prepared Caramel. NOT THE MESQUITE SMOKED.

3. PRODUCTS AFFECTED BY UPC: 45300-29041, 45300-29048, 45300-29051, 45300-23274.

4. AT - PLANT1: Wells MN PLANT2: PLANT3:

5. JUSTIFICATION OF CHANGE INCLUDING COST SAVINGS IN \$/LB: No cost savings but improved shelf life.

6. CHANGE AFFECTS PRINTED PRODUCT LABELS [Y/N]: N IF YES,
-CURRENT LABEL INVENTORIES (AMOUNT & TIME TO USE UP):

-CHOOSE OPTION A, B OR C BY MARKING WITH AN "X"

A. MAKE CHANGE RAPIDLY - GET TEMPORARY LABEL APPROVALS: X

B. MAKE CHANGE RAPIDLY - PRINT NEW LABELS:

C. USE UP LABEL INVENTORY, THEN MAKE CHANGE:

-CHANGES IN NUTRITION DECLARATION OR PORTION SIZE [Y/N]:
IF YES, SPECIFY:

7. CHANGE AFFECTS PQC PROGRAMS [Y/N]: N

8. DOCUMENTS AFFECTED (MARK ALL THAT APPLY & ATTACH APPROPRIATE REVISIONS)
FORMULAS: X OPER INSTRUCTIONS: X PROD STANDARDS: X SPECIFICATIONS: X

9. EFFECTIVE DATE OF CHANGE: 1-3-94

APPROVAL SIGNATURES REQUIRED (FILL IN ALL NAMES) -
OPERATIONS: Dave Wiggins/Frank Carroll

BUSINESS: Bryan Zulaica

MARKETING: Dennis Hull/Mark Spengler

PROD DEV: Syed Hussain/Bill Schwartz *Syes*

CORP QA: Keith Brickey/Stam Seavey

PLANT1 PLANT MGR/QA MGR: Terri Mace St. James

PLANT2 PLANT MGR/QA MGR: Brian Green Jim Kerner

PLANT3 PLANT MGR/QA MGR:

TURKEY PROCUREMENT: Dick Sarvas

APP'D:

APP'D:

APP'D:

APP'D:

APP'D: *[Signature]*

APP'D:

APP'D:

APP'D:

APP'D:

OTHERS TO BE NOTIFIED (INCLUDE MARKETING SERVICES. FRANK ALEXANDER, KAY JAKA
LYNNE MURRAY AND TARA ROSE O'MALLEY AUTOMATICALLY NOTIFIED ON EACH CHANGE) -

OTHER1: Ted Berry

OTHER2: Kent Kring

OTHER3: Lee Christiansen

OTHER4: Bruce Tomkin

LOC1: DG

LOC2: DG

LOC3: PDL

LOC4: PDL

RETURN TO DOCUMENTATION MGR: DEBBIE SOMMERIO

CHANGE FORM STATUS: CIRCULATING

DATE: 01/04/94

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CRPF02081

PTO-002377

MAILLOSE PH & CONCENTRATION CHECK SHEET

DATE	TIME	HRS OF PRODUCTION	PH	% CONCEN.	MICRO COUNT
1-3-94	5:30 Am	0	4.55		
"	9:30 Am	4 hr	4.59		
1-5-94	5:45 Am	0	4.73		
	8:20 Am	3 hr	4.80		475 lb
	10:30 Am	5 hr	5.06		470 lb
	12:30 pm	7 hr	4.94		
	2:30 pm	9 hr	4.79		
	6:00 pm	12.3 hr	4.62		
1-6-94	5:30 pm	1 hr	4.66		
	10:30 pm	17 hr	4.57		
1-7-94	3:30 pm	10 hr	4.66		
1-10-94	9:30 am	4 hr	4.80		
1-13-94	9:30 am	without citric	4.30		
	start	With Citric Acid	3.74		
		+ .225 lb	3.50		
		With CA	3.88		
		+ .225 lb	4.10		
	10:30 am		3.88		
	11:10 Am		4.10		
	11:30 Am		3.88		
	12:05 pm		4.00		
	12:30 pm		3.40		
	1:15 pm		3.86		
	1:30 pm		3.64		
	2:00 pm		3.73		
	2:15 pm		3.30		
	4:00		3.61		
	4:30	add from reservoir	3.70		

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CRPF02039

DEPOSITION
EXHIBITHussain 11
12-02Singh
Exhibit No. 5
to 11-28-01
Caryl L. Hardy

PICK

PTO-002378

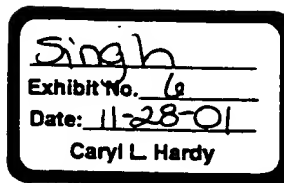
MAILLOSE PH & CONCENTRATION CHECK SHEET

DATE	TIME	HRS OF PRODUCTION	PH	% CONCEN.	MICRO COUNT
1-13-94	4:30 pm		3.70		
	5:00 pm		3.79		
	6:00 pm		3.84		
water (plain out of faucet)			6.19		
	6:30 pm		3.86		
	7:00		3.61	- Added rest of Jump and 1 lb. citric Acid	
	7:30			- Supper	
	8:00		3.71		
	8:30		3.74		
	9:00		3.75		
1-94	5:20 am		4.51		Added .5 lb CA
	/		3.54		Added .25 lb CA
	/		3.33		Added .25 lb CA
	5:45 am		3.15		
	6:05		3.26		
	8:45		4.00		
	10:00	Production Done	4.16	Both	Added .5 lb CA
	10:15		3.88	Both	Added 1.0 lb CA
	10:45		3.53		

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CRPF02040

PTO-002379



DOCUMENTATION CHANGE FORM
REQUESTOR NAME: SYED AJAZ HUSSAIN

DATE: 01/26/94

1. DESCRIPTION OF PROPOSED CHANGE: STOP USING MAILLOSE, AN AQUEOUS SOLUTION OF CARAMEL COLORING WITH A LOW PH 2.5 - 3.5. GO BACK TO USING THE CARAMEL SOLUTION.

2. PRODUCTS AFFECTED BY NAME: SKINLESS SLICE AND SERVE OVEN PREPARED CARAMEL. NOT THE MESQUITE SMOKED.

3. PRODUCTS AFFECTED BY UPC: 45300-29041;29048;29051;23274

4. AT - PLANT1: WELLS, MN

PLANT2:

PLANT3:

5. JUSTIFICATION OF CHANGE INCLUDING COST SAVINGS IN S/LB: NO COST SAVING BUT ADDRESSING THE OPERATIONAL CONCERNS OF THE USE OF MAILLOSE. ADDITIONAL EXHAUST SYSTEM AND OTHER RECOMMENDATIONS OF THE MAILLOSE SUPPLIER WILL HAVE TO BE MET BEFORE MAILLOSE IS USED.

6. CHANGE AFFECTS PRINTED PRODUCT LABELS [Y/N]: N IF YES,
-CURRENT LABEL INVENTORIES (AMOUNT & TIME TO USE UP):

-CHOOSE OPTION A, B OR C BY MARKING WITH AN "X"

A. MAKE CHANGE RAPIDLY - GET TEMPORARY LABEL APPROVALS: X

B. MAKE CHANGE RAPIDLY - PRINT NEW LABELS:

C. USE UP LABEL INVENTORY, THEN MAKE CHANGE:

-CHANGES IN NUTRITION DECLARATION OR PORTION SIZE [Y/N]: N
IF YES, SPECIFY:

5 DAYS SHEET
LIFE

7. CHANGE AFFECTS PQC PROGRAMS [Y/N]: N

8. DOCUMENTS AFFECTED (MARK ALL THAT APPLY & ATTACH APPROPRIATE REVISIONS, FORMULAS: Y OPER INSTRUCTIONS: Y PROD STANDARDS: Y SPECIFICATIONS:

9. EFFECTIVE DATE OF CHANGE: 1-26-94

APPROVAL SIGNATURES REQUIRED (FILL IN ALL NAMES) -

OPERATIONS: DAVE WIGGINS/FRANK CARROLL

BUSINESS: BRYAN ZULAICA

MARKETING: DENNIS HULL

PROD DEV: SYED HUSSAIN/BILL SCHWARTZ

CORP QA: KEITH BRICKEY/STAN SEAVEY

PLANT1 PLANT MGR/QA MGR: DARRELL WEICK/JIM KARRER

PLANT2 PLANT MGR/QA MGR:

PLANT3 PLANT MGR/QA MGR:

TURKEY PROCUREMENT: DICK SARVAS

APP'D:

APP'D:

APP'D:

APP'D:

APP'D:

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APP'D:

APP'D:

APP'D:

OTHERS TO BE NOTIFIED (INCLUDE MARKETING SERVICES. FRANK ALEXANDER, KAY AND LYNNE MURRAY AUTOMATICALLY NOTIFIED ON EACH CHANGE) -

OTHER1: KENT KRING

OTHER2: TED BERRY

3rd Temp

LOC1:

LOC2:

CONFIDENTIAL -

Restricted Access

CRPF02107

PTO-002380

INTEROFFICE MEMORANDUM

DATE: February 11, 1994

TO: DAVE WIGGINS/FRANK CARROLL
BRYAN ZULAICA
DENNIS HULL
SYED HUSSAIN/BILL SCHWARTZ
KEITH BRICKEY/STAN SEAVEY
DARRELL WEICK/JIM KARRER WELLS, MN
DICK SARVAS

CC: KENT KRING DG
TED BERRY DG
BRUCE TOMPKIN PDL
Kay Jakab PDL
Frank Alexander PDL
Lynne Murray PDL
Tara Rose-O'Malley PDL

SUBJECT: CHANGE REQUEST DATED 01/26/94 FOR UPC's
45300-29041;29048;29051;23274

PRODUCT DESCRIPTION: SKINLESS SLICE AND SERVE OVEN PREPARED CARAMEL.
NOT THE MESQUITE SMOKED.

EFFECTIVE DATE: 1-26-94

REQUESTER: Syed Ajaz Hussain

PLANT(S): WELLS, MN, ,

UNAPPROVED CHANGE: Stop using Maillose, an aqueous solution of
caramel coloring with a LOW PH 2.5 - 3.5, and go back to
using the caramel solution.

The above referenced request has NOT been approved through a
documentation change form.

Debbie Sommerio

DEBBIE SOMMERIO
Quality Systems
Downers Grove, IL

Attachment(s)



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Restricted Access

CRP502106

PTO-002381



Proctor & Schwartz, Inc.

251 GIBRALTAR ROAD, HORSHAM, PENNSYLVANIA 19044
PHONE: (215) 443-5200 TELEX: 6851098 FAX: (215) 443-5206

Imp BB

April 29, 1994

Mr. Stanley G. Gershenson
ARMOUR SWIFT-ECKRICH
3131 Woodcreek Drive
Downers Grove, IL 60515-5429

Dear Stan:

Thanks to you and Mike McDonough for keeping me in the loop. I'm willing to put great effort into a project with a 60% chance or more of success. But time is limited if we all invest in something that hasn't got to the starting gate yet. We both miss other opportunities.

Where we stand now is an oven "browning" time of about seven minutes, using Maillose. Yield is 96% or higher on all tests; and product was considered excellent. Not a salesman's term, Stan; your folks said it.

Based on a belt loading of 3 Breasts across on the 24 inch belt, the capacity is approximately 10 Breasts per 17 foot section per minute - 600 per hour. One section is about \$225,000.

So, the math is straightforward. But the key question isn't how many birds and how many sections? It's "who decides to invest" in the market, take the risk.

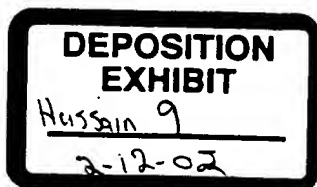
I want to stop and see you as soon as I can to go over your results so we stay in close communication. However, there is no urgency at this time. The tests are done; the data is in.

What we do next is out of our hands.

Let's keep in touch. My regards to Mike.

Sincerely,

Jim Hutchison
Product Manager
Processed Food Division



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Attorneys Only

CRPF04909

PTO-002382